Work Order ID 79492

Thursday, January 26, 2012 2:04:53 PM

79492

RUSH

Item ID: D3340-7

Revision ID:

Item Name: Fwd Skidtube Protector

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 1/26/2012 **Start Qty:** 4.00 *4*

Required Date: 1/27/2012 **Req'd Qty:** 4.00 *4*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** AMK **Date:** 12-01-26 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3340	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Waterjet FLOW CNC Waterjet 1010 .040	FLOW WATER JET	0.00				B12-1-27			
	Memo 1-Cut as per Dwg D3340 Dwg Rev: B Prog Rev: B 2-Deburr if necessary	0.00							(4)
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00				B12-1-27			
	Memo	0.00							
120 *120* QC Quality Control	QC8- Inspect parts - second check	0.00							
	Memo	0.00 S12/01/27				(stamp)			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 79492

Thursday, January 26, 2012 2:04:53 PM

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Item ID: D3340-7

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Item Name: Fwd Skidtube Protector

Accept *N900040100*

Setup Start *NS1*

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Start Date: 1/26/2012 **Start Qty:** 4.00 *4*

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Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE	0.00				(4)			
	Memo Deburr if necessaryForm on brake as per Dwg D3340 using Jigs DT 8326 and DT 8261 SB 12/01/30	0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				(4)			
	Memo S 12/01/30	0.00							
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				4X MJ 12/01/30			
	Memo START TIME: 8:20 OVEN TEMPERATURE: 320°F FINISH TIME: 8:50	0.00							

M118484

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 79492 *79492*

Thursday, January 26, 2012 2:04:53 PM

Item ID: D3340-7 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Fwd Skidtube Protector **Stop** *NS2*

Start Date: 1/26/2012 **Start Qty:** 4.00 *4* **Cust Item ID:**

Required Date: 1/27/2012 **Req'd Qty:** 4.00 *4* **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				4x counted	4	M	12/01/36
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: 499 **Memo**	0.00 0.00				6/1/30	(4)		[illegible]
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00				12/1/30			[illegible]

12-01-30 (4)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, January 26, 2012 2:04:52 PM

Work Order ID: 79492

Parent Item: D3340-7

Parent Item Name: Fwd Skidtube Protector

Start Date: 1/26/2012 **Required Date:** 1/27/2012

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC
IPP Rev:B Now on Waterjet 06-09-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA 1010/1025 SHEET		Purchased	No			100	sf	121.7000	**0.889**	**3.7431579** B 12-1-27			

Location		Loc Qty	Loc Code
MAT019		121.7	
	111410	45.2	
	116791	76.5	

116791

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

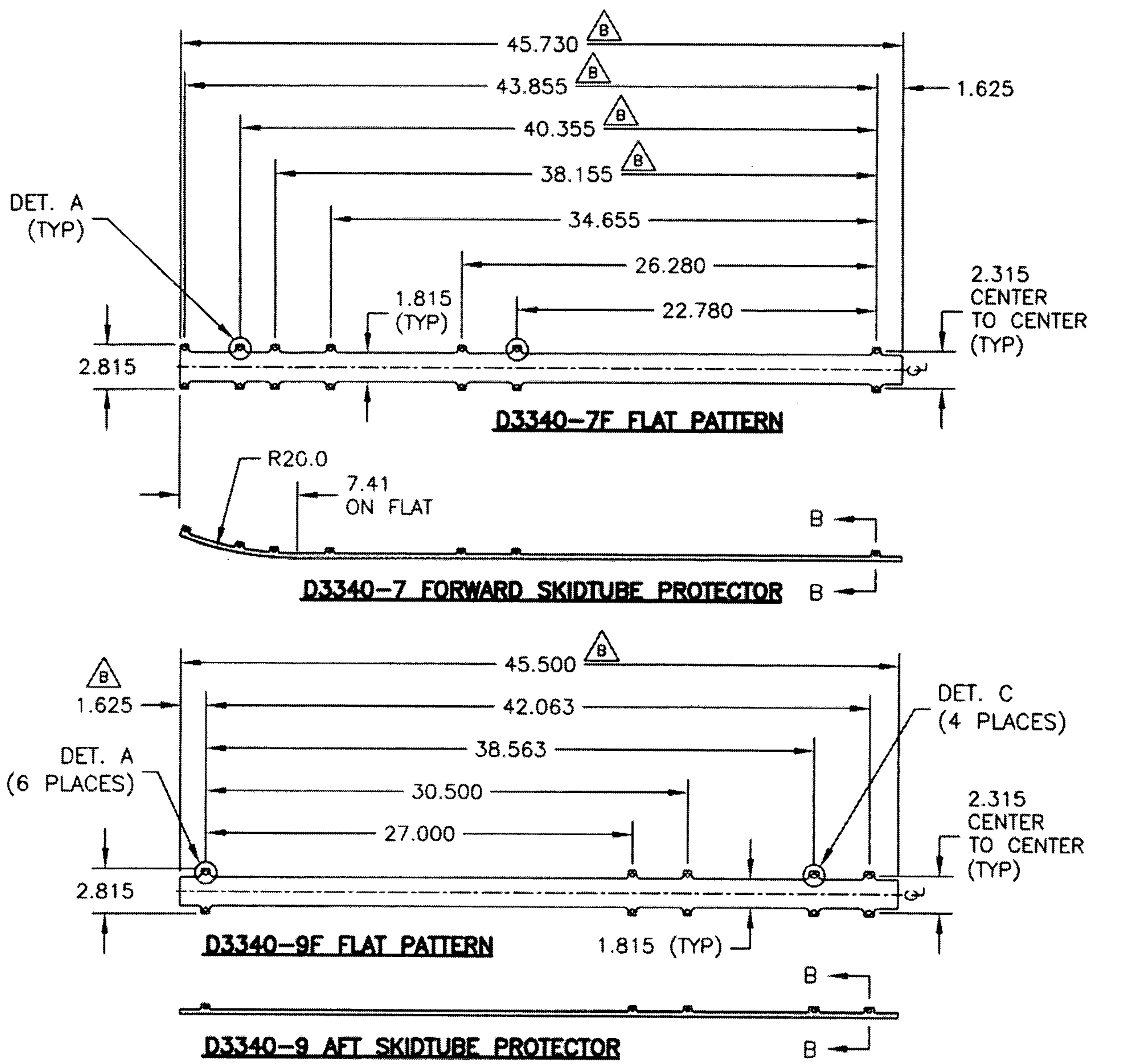
Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
MB	MB		
CHECKED	APPROVED	DRAWING NO. D3340	REV. B SHEET 4 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



NOTES:

1) MATERIAL: AISI 1010–1025 OR ASTM A36/A366/A1008 OR CSA G40–21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
2) PART IS SYMETRICAL ABOUT CENTER LINE
3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED 05.11.28

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

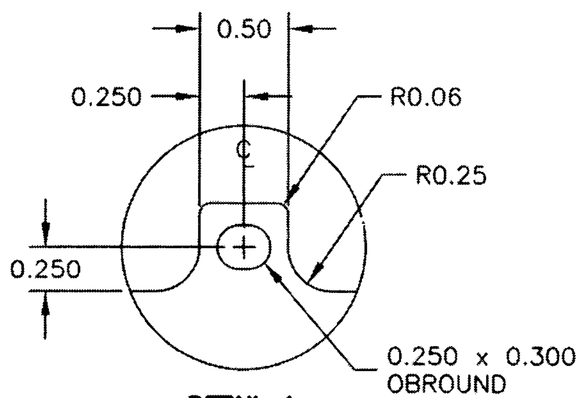
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

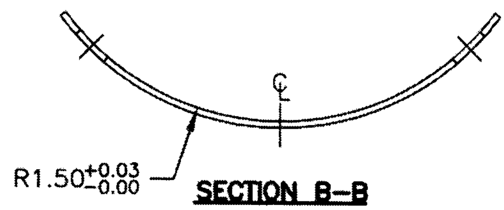
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
MB	MB	
CHECKED	APPROVED	DRAWING NO. D3340 — REV. B — SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR — SCALE 1:1

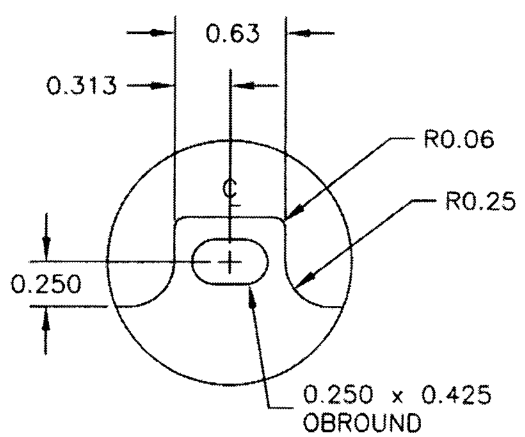
RELEASED 05-11-28



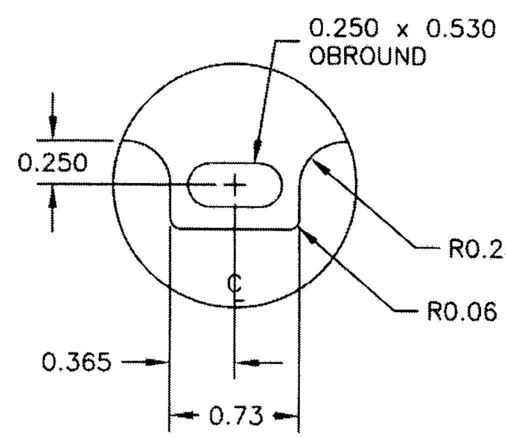
DETAIL A



SECTION B–B



DETAIL C



DETAIL D B

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	79492
Description: Fwd Skidtube Protector	Part Number:	D3340-7
Inspection Dwg: D3340 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250 x 0.300	+/-0.010	.248 x .300	✓		V RB02	
0.50	+/-0.030	.500	✓		V	
0.250	+/-0.010	.251	✓		V	
1.625	+/-0.010	1.625	✓		V	
2.815	+/-0.010	2.809	✓		V	
2.315	+/-0.010	2.320	✓		V	
1.815	+/-0.010	1.820	✓		V	
22.780	+/-0.010	22.780	✓		T TB01	
26.280	+/-0.010	26.280	✓		T	
34.655	+/-0.010	34.655	✓		T	
38.155	+/-0.010	38.155	✓		T	
40.355	+/-0.010	40.355	✓		T	
43.855	+/-0.010	43.855	✓		T	
45.730	+/-0.010	45.730	✓		V	

Measured by:	[signature]	Audited by:	[signature]	Prototype Approval:	N/A
Date:	12-1-27	Date:	12/01/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD [signature]	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries